

Date: Thursday, 19/03/2009 11:05:54 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FLOOR PROTCOR LH
Job Number : 46584	
Estimate Number : 11226	
P.O. Number :	Part Number : D32801
This Issue : 19/03/2009 S.O. No. :	Drawing Number : D3280 REV. D
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : THERMOFORMING	Drawing Revision : D
Previous Run : 45705	Material :
Written By :	Due Date : 02/04/2009 Qty: 5 Um: Each
Checked & Approved By : <u>Jul 09.03.19</u>	
Comment : Est Rev:A 04.07.01 New issue KJ/JLM	
Est RevB 07.09.12 Thermoform in house DL	
Est. Rev. C 08.03.11 Dwg. Rev Change DL	
Est Rev. D 08.04.15 Material Change DL	

Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description :

1.0

MLEXS093F600602

GE PLASTICS LEXAN SHEET



Comment: Qty.: 4.3330 sf(s)/Unit Total : 21.6650 sf(s)
 GE PLASTICS LEXAN SHEET

Material Batch Number M110877

DL 09/03/19

2.0

HAND FINISH TH

HAND FINISHING THERMOFORMING

**Comment:** HAND FINISHING THERMOFORMING

1) Cut Blanks

DL 09/03/19

3.0

THERMOFORMING

THERMOFORMING MACHINE

**Comment:** THERMOFORMING MACHINE

Thermoform as per Dwg. D32811and Folio FTA 011

Dwg. Rev. DFolio Rev. B

DL 09/03/19

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

DL 09/03/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 19/03/2009 11:05:54 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROTECTOR LH

Job Number: 46584

Part Number: D32801

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



(x5)

Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

DL. 09/03/23

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

1) Check Surface finish for undesired marks, voids, dimples etc.

2) Check dimensions to ensure conformity to drawing tolerances.

DL. 09/03/23

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

ST142

S 09/03/23 (x5)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/24 JF

Job Completion



MF 09-03-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 410587
Description: R22 Floor Protector, LH		Part Number: D3280-1
Inspection Dwg: D3280	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than 0.1875"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

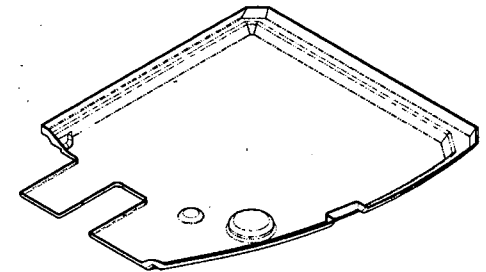
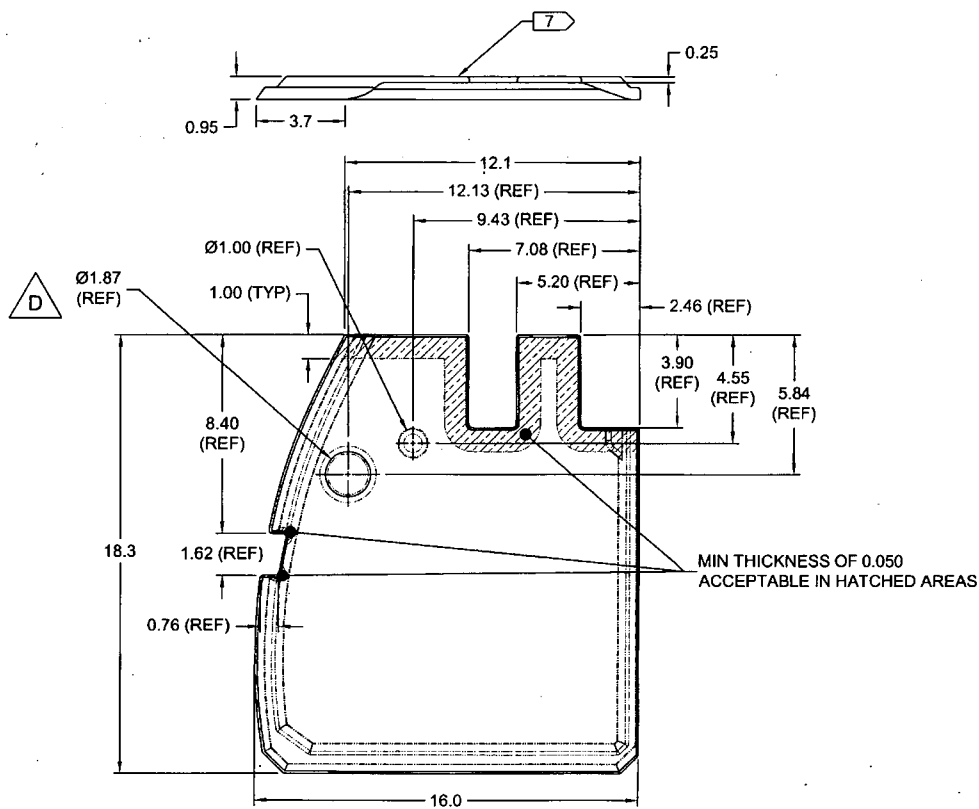
Measured by: <i>Wh</i>	Date: 09/03/23
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
18.3	+/-0.100	18.3	✓			
16.0	+/-0.100	15.9	✓			
12.1	+/-0.100	12.0	✓			
0.95	+/-0.030	0.97	✓			
0.25	+/-0.030	0.261	✓			
0.070	Min	0.074	✓			
0.050	Min	0.055	✓			

Measured by: <i>Wh</i>	Date: 09/03/23
Audited by: <i>JB</i>	Date: 09/03/23
Prototype Approval: N/A	Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/DL	
B	08.04.16	Dimensions updated per Dwg Rev D	KJ/DL <i>AJ</i>	<i>OK</i>



D3280-1 FLOOR PROTECTOR

D3280-1 NOTES:

- 1) THERMOFORM WITH MOLD D3280-1T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK
(REF DART SPEC MLEXS.093-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3280-1" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS
- 8) WEIGHT: 0.94 lb

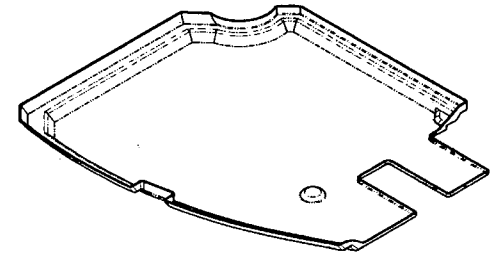
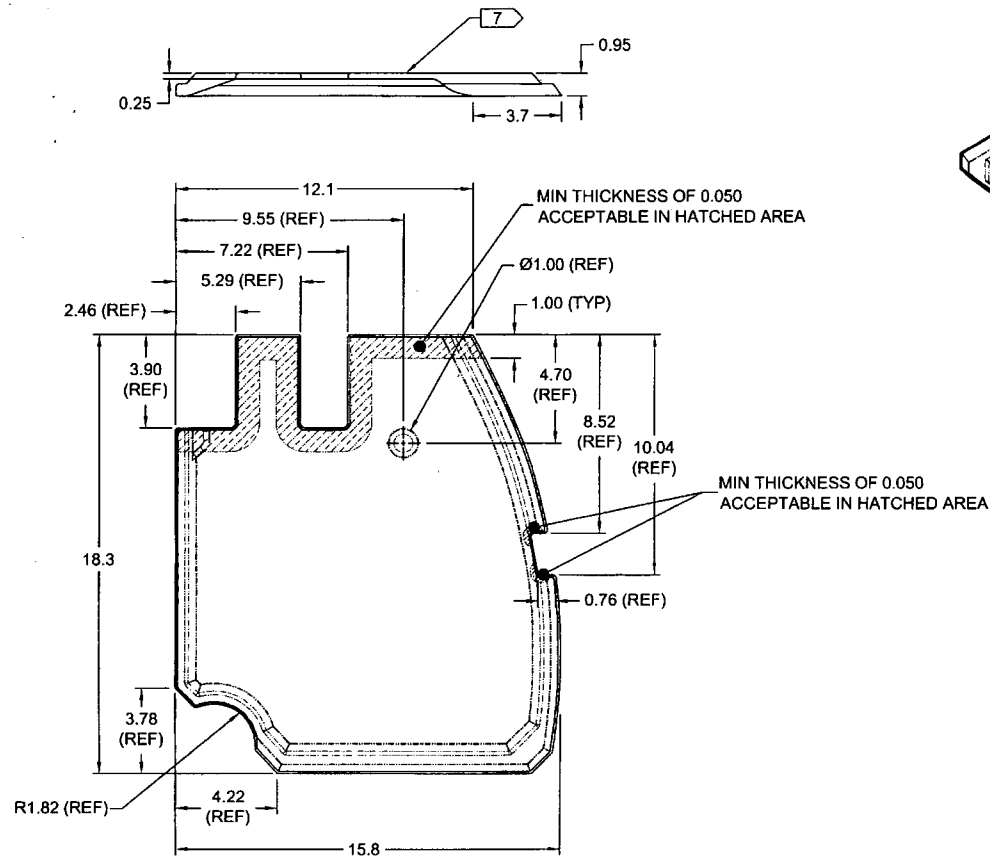
D	THICKNESS 0.093 WAS 0.125, MIN. THICKNESS 0.070 WAS 0.080, P/N & B/N ID WITH VIBRATING STYLUS (ZN A7-1, A7-2); CORRECT WEIGHTS (ZN A8-1, A8-2); HOLE SIZE Ø1.88 WAS Ø0.211 (ZN C7-1)	PH	08.03.28
C	UPDATE DIMS TO MATCH PARTS; COLOUR 701 WAS 700; GENERAL UPDATE	LE	07.10.12
B	NOW LEXAN; DIMS AS MANUFACTURED	CP	05.11.25
A	NEW ISSUE	CP	04.05.03
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.03.28		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3280
SHEET 1 OF 2
TITLE FLOOR PROTECTOR
SCALE NTS

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D3280-3 FLOOR PROTECTOR

D3280-3 NOTES:

- 1) THERMOFORM WITH MOLD D3280-3T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK
(REF DART SPEC MLEXS.093-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3280-3" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS
- 8) WEIGHT: 0.88 lb

DART AEROSPACE LTD

HAWKESBURY, ONTARIO, CANADA

DESIGN		DRAWING NO.	REV. D
DRAWN		D3280	SHEET 2 OF 2
CHECKED		TITLE	SCALE
MFG. APPR.		FLOOR PROTECTOR	NTS
APPROVED		DATE 08.03.28	
DE APPR.		COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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